

TODAY

Dart Aerospace Ltd.

Date: Thursday, 29/03/2007 1:11:07 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: HEAT OUTLET DEFLECTOR
<b>Job Number</b>	: 31535	<b>Part Number</b>	: D34721 - 5
<b>Estimate Number</b>	: 12154	<b>Drawing Number</b>	: D3472 REV.A
<b>P.O. Number</b>	: N/A	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 29/03/2007	<b>Drawing Revision</b>	: A
<b>Prsht Rev.</b>	: NC	<b>Material</b>	: N/A
<b>First Issue</b>	: N/A	<b>Due Date</b>	: 05/04/2007
<b>Previous Run</b>	: 26273	<b>Qty:</b>	2
<b>Written By</b>	:	<b>Um:</b>	Each
<b>Checked &amp; Approved By</b>	:		
<b>Comment</b>	: est rev. A 06.02.02 new issue EC		

## Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S083 40	2024-T3 .063 sheet
<p>Comment: Qty.: 0.0573 sf(s)/Unit Total : 0.1147 sf(s)</p> <p>2024-T3 .063 sheet</p> <p>Batch: M103321</p> <p>M103039</p> <p>ml 07 03 30</p> <p>7.040"</p> <p>07 03 30</p>		
2.0	WATER JET	FLOW WATER JET
<p>Comment: FLOW WATER JET</p> <p>Cut as per Dwg D3472</p> <p>Dwg Rev: A</p> <p>Prog Rev: A</p> <p>ml 07 03 30</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p>ml 07 03 30</p>		
4.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK</p> <p>J.F 07/03/30</p>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1</p> <p>1- Deburr</p> <p>2-Bend as per dwg D3472</p> <p>3-Buff-out any marks due to bending</p> <p>FF 07/03-30</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAT OUTLET DEFLECTOR

Job Number: 31535

Part Number: D34721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/30

(2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07-03-30

2

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/03/30

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/03/30

(2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/03/30

(2)

Job Completion



SB 07/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

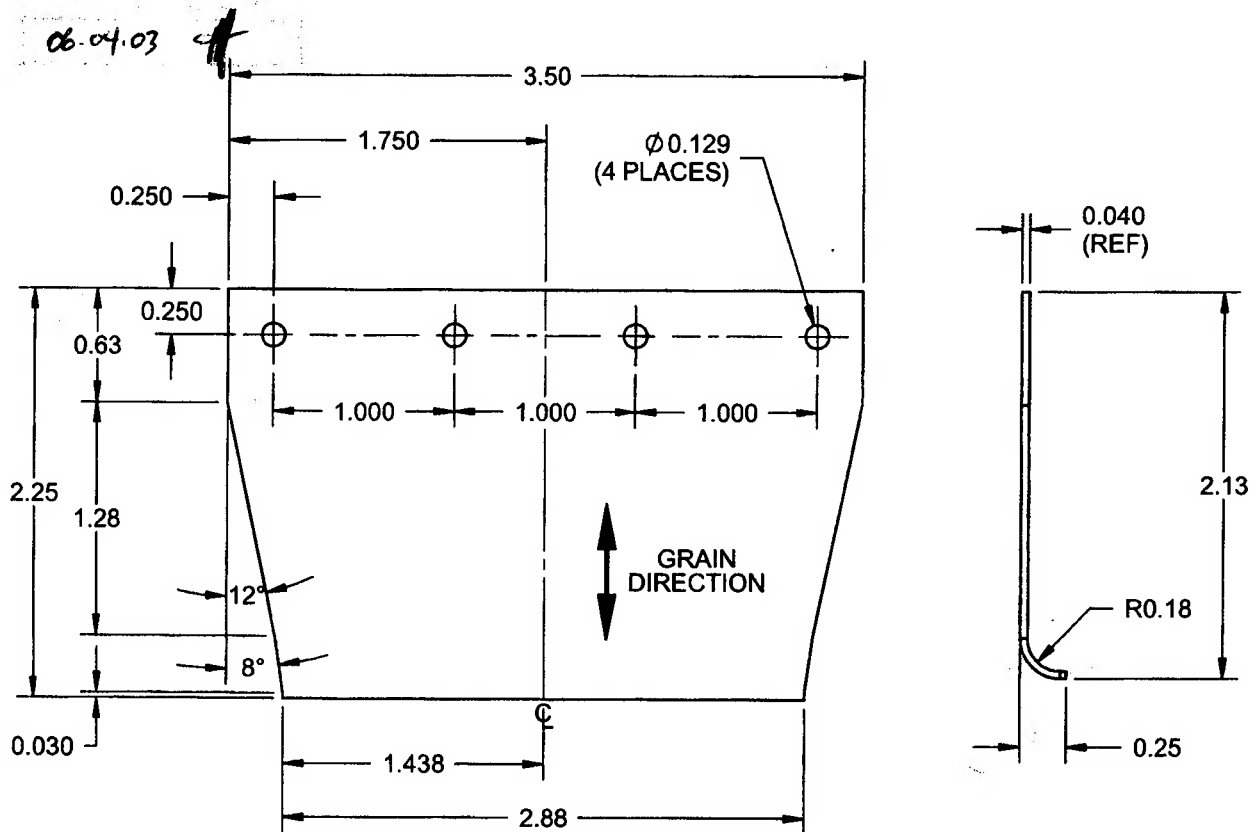
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3472</b>	REV. A SHEET 2 OF 4
DATE <b>06.01.17</b>		TITLE <b>HEAT OUTLET DEFLECTOR</b>	SCALE 1:1

**D3472-1F FLAP FLAT PATTERN****D3472-1 FLAP  
BENDING DETAIL**

*W/O 31535*

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31535
<b>Description:</b> Heat Outlet Deflector		<b>Part Number:</b> D3472-1
<b>Inspection Dwg:</b> D3472 <b>Rev:</b> A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A Ø 0.129	+0.005-0.001	0.129	✓		VERN	
B 0.25	+/-0.030	2.258	✓		VERN	
C 3.50	+/-0.030	3.505	✓		VERN	
D 0.250	+/-0.010	0.254	✓		VERN	
E 0.250	+/-0.010	0.254	✓		VERN	
F 2.88	+/-0.030	2.85	✓		VERN	
G 1.000	+/-0.010	1.004	✓		VERN	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

<b>Measured by:</b> M.M.A	<b>Audited by:</b> S.K.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/03/30	<b>Date:</b> 07/03/30	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
		New Issue	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 31535
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Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 0.129	+0.005/-0.001	0.129	✓		vern	
B	2.25	+/-0.030	2.253	✓		vern	
C	3.55	+/-0.030	3.505	✓		vern	
D	0.250	+/-0.010	0.250	✓		vern	
E	0.250	+/-0.010	0.251	✓		vern	
F	2.88	+/-0.030	2.87	✓		vern	
G	1.000	+/-0.010	1.001	✓		vern	
H	0.63	+/-0.030	0.63	✓		vern	
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
		New Issue	KJ/RF	